

Work Order ID 85187

Monday, June 04, 2012 1:11:12 PM

85187

Page 1

Item ID: PB67-43001-67

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: PB67-43001-67

Start Date: 6/4/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/15/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *ME*Date: *12-06-04* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001-67

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg B67-43001-147

Dwg Rev: *C*Prog Rev: *C*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

*B1265**B1265*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Srz/6/6/12

(43)

130

Small Fab

0.00

130

Small Fab

Memo

0.00

Small Fab

Form as per dwg B67-43001

(3)

8
12/06/13

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

3

12/06/13

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N9000040100

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2

Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00

150

Large Fab

1- Install nut plates on side plate as per dwg

3RH
3LH

12/06/14

Large Fab

Memo

0.00

Large Fab

2- Weld assembly as per dwg B67-43001

CL 12-6-18

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Memo

0.00

Quality Control

3 0 BE 12/06/18

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

8/7/6/18

8

W/O:		WORK ORDER CHANGES					
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Required Date: 6/15/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

180

Small Fab

Small Fab

Small Fab

Memo

Assemble as per dwg B67-43001

0.00

0.00

190

190

QC

Quality Control

QCS- Inspect part completeness to step on W/O

Memo

0.00

0.00

200

200

Packaging

Packaging

Identify as per dwg & Stock Location: W/A

Memo

0.00

0.00

1 ϕ

12.06.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/6/18

ME
12-06-18

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Picklist Print

Monday, June 04, 2012 1:11:11 PM

Page 1

Work Order ID: 85187

Parent Item: PB67-43001-67

Parent Item Name: PB67-43001-67

Start Date: 6/4/2012

Required Date: 6/15/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-06-19 new issue DD verified by:ec
IPP Rev:B 08-09-23 remove alodine and QC3 DD verified EC IPP rev B 10.09.30 per rev C
dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.090 6061-T6 .090 Sheet		Purchased	No			150	sf	79.3000	0.5944	1.2513684	2	B12-6-5	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		79.3							
				109184		2			109184				
				111382		77.3							
MS20426AD3-4 RIVET		Purchased	No			100	Each	3,000.0000	12	24		B12/06/14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST316		3000							
				104374		382			36				
				110398		2618							
MS21075L3 Nutplate		Purchased	No			180	Each	91.0000	6	12		B12/06/14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		46							
				121090		46			18				
				ST303		1							
				120910		1							
				ST321		44							
				121825		44							
PB67-43001-149 Side Plate		Manufactured	No.			180	Each	12.0000	2	4		B12/06/14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		12							
				41560		12			6				

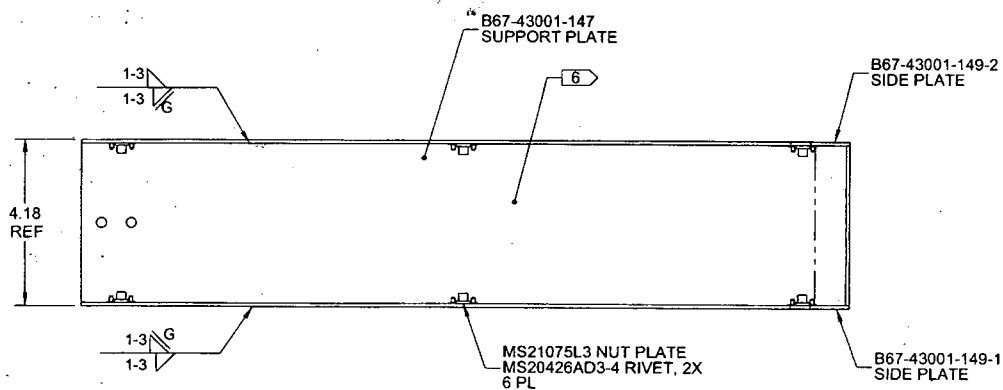
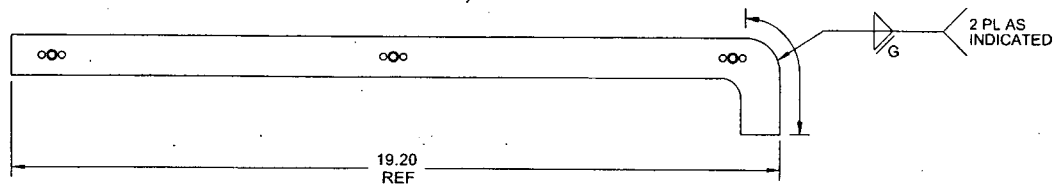
W/O:		WORK ORDER CHANGES					
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B67-43001-67 90-DEGREE BLADE SUPPORT ASSY

ITEM	QTY -67	P/N	DESCRIPTION
1	X	B67-43001-67	90-DEGREE SUPPORT PLATE ASSY
2	1	B67-43001-147	SUPPORT PLATE
3	1	B67-43001-149-1	SIDE PLATE
4	1	B67-43001-149-2	SIDE PLATE
5	12	MS20426AD3-4	RIVET
6	6	MS21075L3	NUT PLATE

#85187

RELEASED
2010-09-16
MB

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-67" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.11 lbs
 - 8) WELDING: PER QSI 004

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 9 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-67 TITLE 90-DEGREE BLADE SUPPORT ASSY SCALE NTS <small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED	MB			
DE APPR.	N/A			
DATE	10.04.28			

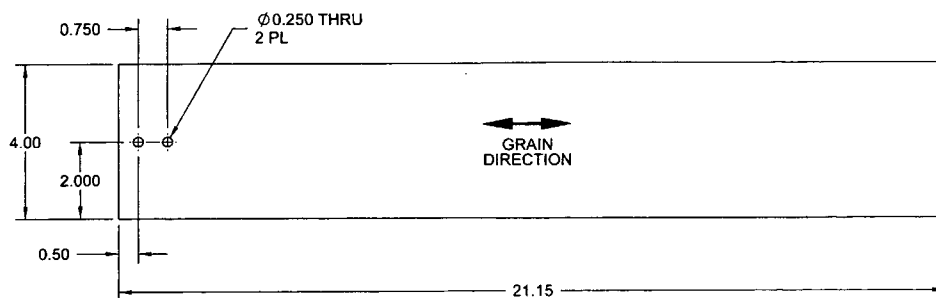
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

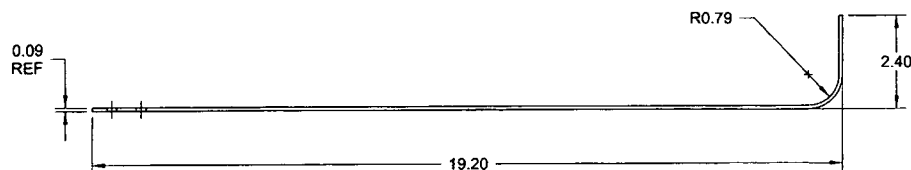
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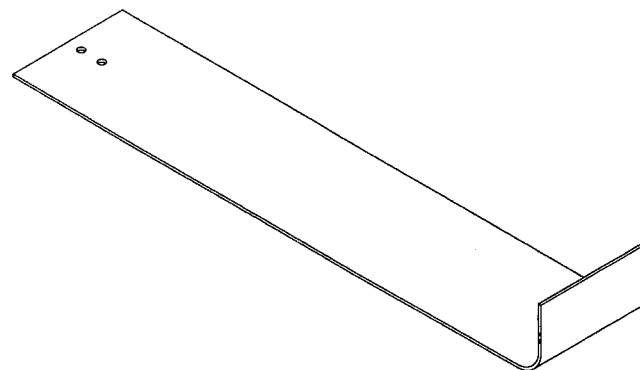
B67-43001-147F SUPPORT PLATE FLAT PATTERN



B67-43001-147 SUPPORT PLATE
(MAKE FROM B67-43001-147F)

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.090 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF. DART SPEC. M6061T6S.090
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.74 lbs



RELEASED
2009-09-23
N/A

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 24 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.03.03
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	ASS		DRAWING NO.	REV.
MFG. APPR.	2/10/03		B67-43001-147	SHEET 1 OF 1
APPROVED	N/A		TITLE	SCALE
DE APPR.	N/A	SUPPORT PLATE	NTS	
DATE	09.03.03	COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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